

Work Order ID 76498

Tuesday, November 15, 2011 4:00:17 PM

76498

Page 1

Item ID: D3325-041

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Basket Lid Assembly

Stop

NS2

Start Date: 11/15/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 11/25/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date: 11/11/15

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr	
D3325	Rev B	
100		0.00
100	Large Fab	
Large Fab	Memo	0.00
Large Fab	1-Cut tubes as per Dwg D3325	

Qty	Part Number	Description	Batch
2	D3325-1	End Tube	119683
3	D3325-3	Interior Tube	119683
2	D3325-5	Full Length Tube	119683

Identify parts appropriately

2-Remove all markings from material

3-Drill and Weld as per Dwg D3325 & QSI 004
A/R4130 Steel Rod 118875

4-Deburr as required

PL 11/11/25

1X

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N900040100

Setup

Start

NS1

Revision ID:

Item Name: Basket Lid Assembly

Stop

NS2

Start Date: 11/15/2011 **Start Qty:** 1.00

1

Cust Item ID:

Required Date: 11/25/2011 **Req'd Qty:** 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

**Sequence ID/
Work Center ID**

**Operation
Description**

**Set Up/
Run Hours**

Tool ID

Tool #

**Plan
Code**

**Accept
Qty**

**Reject
Qty**

**Reject
Number**

**Insp.
Stamp**

130

130

Powdercoat

Powder Coating

W118439

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

3:10 0.00
400°F

XJMF 11/11/08

1ST COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

***** 2nd coat if necessary *****

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

3:50 0.00
400°F
4:20

140

QC3- Inspect Part Finish

0.00

140

QC

Quality Control

Memo

0.00

1 PR 11-11-08

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Page 4

Item ID: D3325-041**Accept*****N900040100*****Setup****Start*****NS1*****Revision ID:****Stop*****NS2*****Item Name:** Basket Lid Assembly**Start Date:** 11/15/2011 **Start Qty:** 1.00***1*****Cust Item ID:****Required Date:** 11/25/2011 **Req'd Qty:** 1.00***1*****Customer:****Reference:****Approvals:****Process Plan:** _____**Date:** _____**Tooling:** _____**Date:** _____**Run****Start*****NR1*****QC:** _____**Date:** _____**SPC (Y/N):** _____**Date:** _____**Stop*****NR2*****Sequence ID/
Work Center ID****Operation
Description****Set Up/
Run Hours****Tool ID****Tool #****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

150

150

Packaging

Packaging

Identify as per dwg & Stock Location: *6-A*

0.00

*w/b
76490 (A)**EJ 11/11/29 Q*

160

160

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

*11/11/29 JF**MF
11-11-29*

Picklist Print

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Work Order ID: 76498

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D3325-041

Parent Item: D3325-041

Parent Item Name: Basket Lid Assembly

Start Date: 11/15/2011

Required Date: 11/25/2011

Start Oty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A05.02.09New issueKJ/JL

IPP Rev:B 08-12-16 attach DEO DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3328-1 *D3328-1* Basket Hinge		Manufactured	No			100	Each	17.0000	2	2		PCL 11.11.21	
D3349-1 *D3349-1* Spacer Bushing		Manufactured	No		<u>Location</u> WA005 33871		<u>Loc Qty</u> 17 17				2	PCL 11.11.21	
D3352-1 *D3352-1* Label Plate		Manufactured	No		<u>Location</u> WA005 44401		<u>Loc Qty</u> 22 22				1	PCL 11.11.21	
D3367-1 *D3367-1* Mounting Bracket		Manufactured	No		<u>Location</u> WA005 41925		<u>Loc Qty</u> 11 11				2	PCL 11.11.21	
							<u>Loc Qty</u> 8						
							<u>Loc Qty</u> 8						

Picklist Print

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Tuesday, November 15, 2011 4:00:21 PM

Work Order ID: 76498

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Parent Item: D3325-041

D3325-041

Parent Item Name: Basket Lid Assembly

Start Date: 11/15/2011

Required Date: 11/25/2011

M4130NTS0.500W.035

Purchased

No

100

f

307.3682

20.5416

21.62274

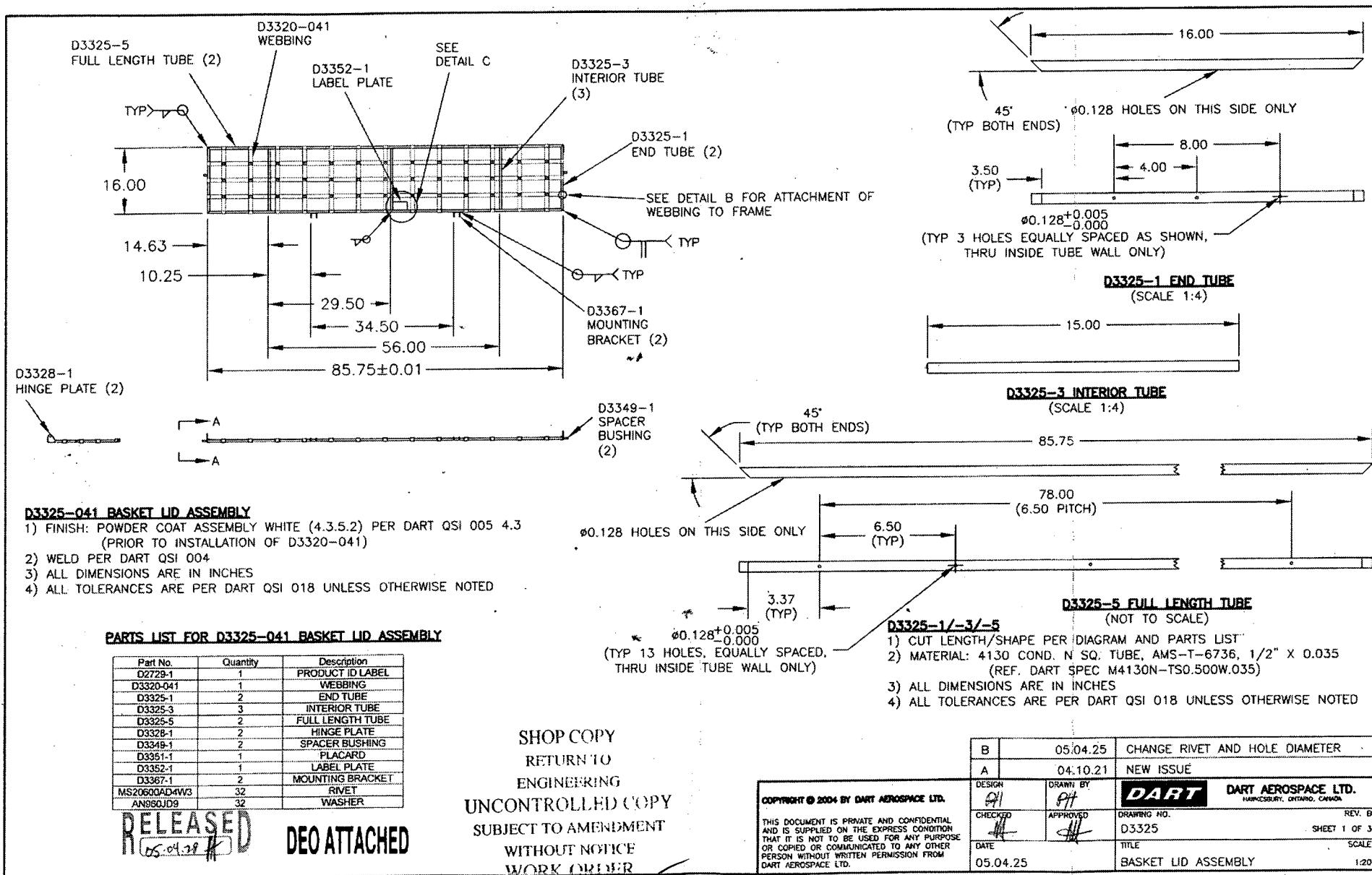
**

M4130NTS0.500W.035

4130 Square tube .500 x .500 x .035w

*PL 11-11-21**m119683 → 21.62274*

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT034	307.3682	
109127	158.152	
109385	15.75	
112786	39.2488	
119441	57.8774	
119506	36.34	



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

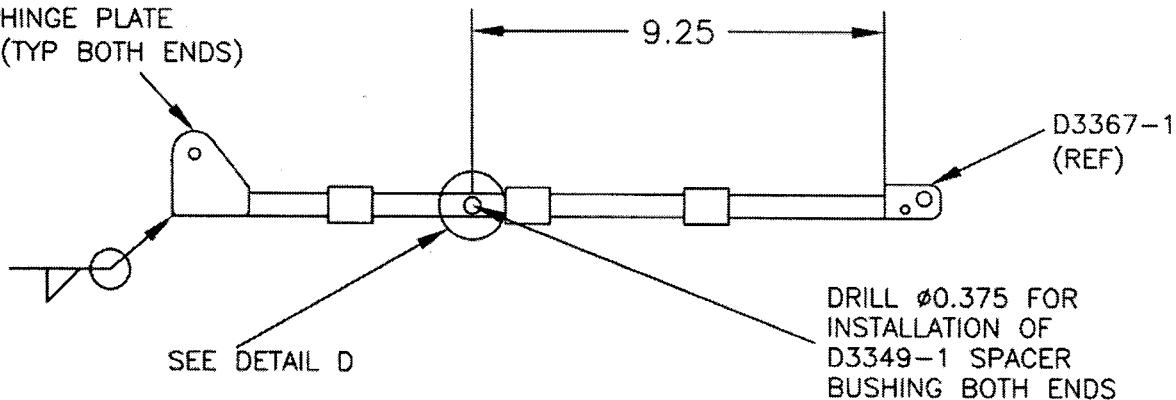
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



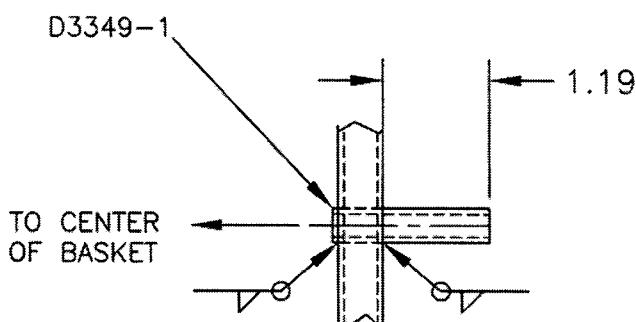
DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D3325	REV. B SHEET 2 OF 3
DATE 05.04.25		TITLE BASKET LID ASSEMBLY	SCALE 1:4

D3328-1
HINGE PLATE
(TYP BOTH ENDS)



VIEW A-A

PHM



DETAIL D
(SCALE 1:2)

DEO ATTACHED

RELEASED
05.04.28 *PH*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

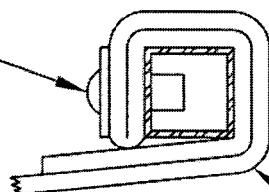
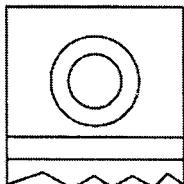
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D3325
DATE 05.04.25		REV. B SHEET 3 OF 3 TITLE SCALE BASKET LID ASSEMBLY 1:4

MS20600AD4W3 RIVET (1)
AN960JD9 WASHER (1)



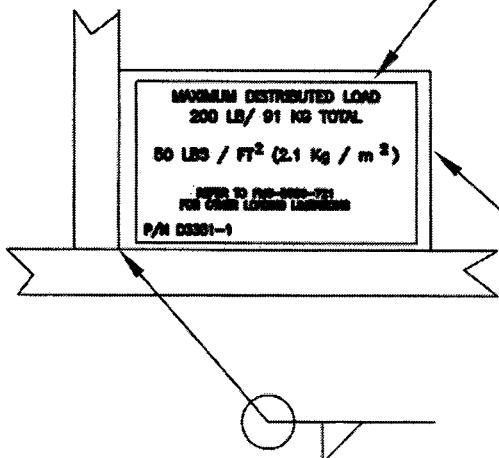
D3320-041 WEBBING

DETAIL B
TYP. ATTACHMENT OF WEBBING TO LID
FRAME
(SCALE 1:1)

PH
RELEASED
05.04.28 *PH*

DET ATTACHED

ATTACH D3351-1 PLACARD
ON TOPSIDE OF D3352-1



OUTBOARD

IDENTIFY WITH DART P/N
D350-721-041 USING
D2729-1 PRODUCT ID LABEL
INSTALLED ON UNDERSIDE OF
D3352-1

DETAIL C
LABEL PLATE ATTACHMENT
(SCALE 1:2)

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DRAWING NO. D3325	TITLE BASKET LID ASSEMBLY	REV. B	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D3325-B-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN AJS	CHECKED <i>[Signature]</i>	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DE APPR. <i>[Signature]</i>		
DATE 08.11.28	DATE 08.11.28	DATE 08.12.01	DATE 08.12.01	DATE 08.12.01	DATE 08.12.01	

1) SHEET 1 MODIFY PARTS LIST AS SHOWN:

PART LIST FOR D3325-041 BASKET LID ASSEMBLY

Part No.	Quantity	Description

IS:

MS20600AD4W5	32	RIVET

WAS:

MS20600AD4W3	32	RIVET

76468

2) UPDATE SHEET 3 DETAIL B ACCORDINGLY.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries